



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

Order 1941

5053104

26

RBST2854-5
Job Sheet 173095



Part No: RBST2854-5

Job Qty: 12 ea

DAS
13
9-89

MAR 12 2018

Part Name: Roller



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/26/18

Job Tracking No:

Due Date: 3/9/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBST2854 Rev 1 IPP Rev A 18.02.22 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Outsource	12 pcs		3/9/18	0.00	0.00	Outsource16		AT 8/13/21
110	Packaging	12 pcs		3/9/18	0.00	0.00	Packaging2		AT 163/21
120	QC	12 pcs		3/9/18	0.00	0.00	QC6		38
130	Packaging	12 pcs		3/9/18	0.00	0.00	Packaging3-2		MA 18/22/26
140	QC21-SA	12 Ea		3/9/18	0.00	0.00	QC21		GA 13/21

Part Op 100 - ISSUE P/O: 09202 TO KG GRINDING. MANUFACTURE AS PER DWG. SHIP QTY REQUIRED OF
Descriptions: 89031009

DAS
21
9-89

MAR 27 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
89031009	Plug and Pin Gauge	36 Ea (3 ea)	100-Outsource	5046388

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Outsource	89031009	36	4	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

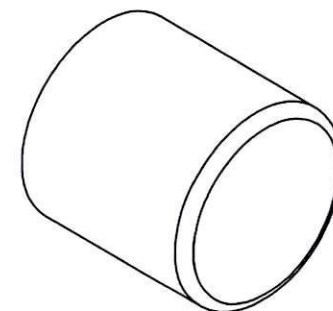
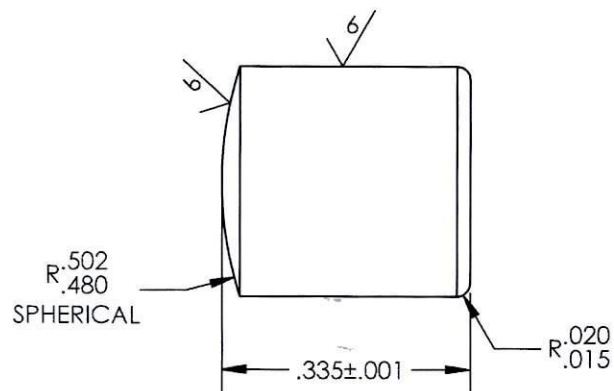
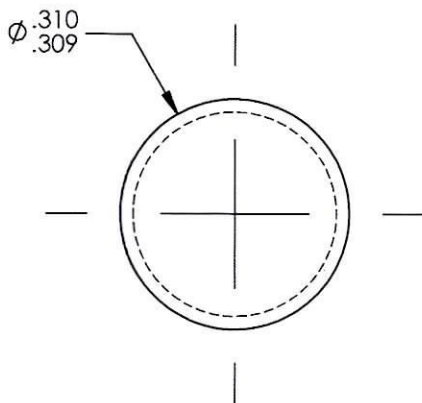
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																							
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval																																																					
Descri				Completed By																																																					
Job No: 173095 Mfg Date: 03/20/18 Change No: Operation: Revision: Serial No/Batch: S053104 PART NO: RBST2854-5		Roller 		Lead hand / Supervisor Approval Verification																																																					
				QC / QA Coordinator Approval																																																					
<table border="1" style="width:100%; border-collapse: collapse;"> <thead> <tr> <th colspan="4" style="text-align: left;">Root Cause</th> </tr> </thead> <tbody> <tr> <td>Environment</td><td>☐</td> <td>No Re-</td><td>☐</td> </tr> <tr> <td>Design</td><td>☐</td> <td>Operat</td><td>☐</td> </tr> <tr> <td>Doc/Data</td><td>☐</td> <td>Offset,</td><td>☐</td> </tr> <tr> <td>Equip/Tooling</td><td>☐</td> <td>Suppli</td><td>☐</td> </tr> <tr> <td>Handling/Pre</td><td>☐</td> <td>Trainin</td><td>☐</td> </tr> <tr> <td>Material</td><td>☐</td> <td>Use for Testing</td><td>☐</td> </tr> <tr> <td>Internal Transport</td><td>☐</td> <td>Poor Information</td><td>☐</td> </tr> <tr> <td>Tribal Knowledge</td><td>☐</td> <td>Rushing</td><td>☐</td> </tr> <tr> <td>LOA</td><td>☐</td> <td>Product Improvement</td><td>☐</td> </tr> <tr> <td>Substation</td><td>☐</td> <td>Process Improvement</td><td>☐</td> </tr> <tr> <td>Past Expiry Date</td><td>☐</td> <td>Manufacturing Process</td><td>☐</td> </tr> <tr> <td>Misidentified</td><td>☐</td> <td>Past Due</td><td>☐</td> </tr> </tbody> </table>						Root Cause				Environment	☐	No Re-	☐	Design	☐	Operat	☐	Doc/Data	☐	Offset,	☐	Equip/Tooling	☐	Suppli	☐	Handling/Pre	☐	Trainin	☐	Material	☐	Use for Testing	☐	Internal Transport	☐	Poor Information	☐	Tribal Knowledge	☐	Rushing	☐	LOA	☐	Product Improvement	☐	Substation	☐	Process Improvement	☐	Past Expiry Date	☐	Manufacturing Process	☐	Misidentified	☐	Past Due	☐
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OTHER : _____																																																									

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



(-5)
ROLLER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 173095
ML
1807-26

DART AEROSPACE	
TITLE TRI-ROLLER SWAGING TOOL	
DWG NO. RBST2854-5	REV 1
MAT'L STEEL	DRAWN BY: GILBERT
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	APPROVED <i>D. Weil</i> HEAT TREAT RC 55-60 FINISH SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	212-310-701-103
SCALE 4:1	DATE 5/20/2013 SHEET 4 OF 10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
COPY FOR: - QA TEAM - SUPPLIER - QUALITY CONTROL - MANAGEMENT				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : _____					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO039202

Supplier: AFF001-VC
Affutage K.G. Inc.
11455 Philippe Panneton Ave.
Montreal
QC
H1E 4M1 Canada
Phone: 514 323 0192 514 323 6631
Fax: 514 323 6631

PO No: PO039202

PO Date: 3/5/18

Due Date: 3/14/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

REVISED

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	170734	RBST4241-5	Roller ISSUE P/O: _____ TO KG GRINDING. MANUFACTURE AS PER DWG. SHIP QTY REQUIRED OF 89031009	Firmed	3/14/18	6 pcs	0 pcs <i>6x</i>	6 pcs <i>AT</i>	\$12.00/pcs	\$72.00
2	173095	RBST2854-5	Roller ISSUE P/O: _____ TO KG GRINDING. MANUFACTURE AS PER DWG. SHIP QTY REQUIRED OF 89031009 1 pin make 4 pcs	Firmed	3/14/18	26 pcs	0 pcs <i>26x</i>	26 pcs	\$12.00/pcs	\$312.00
3	170733	RBST1016-5	Roller ISSUE P/O: _____ TO KG GRINDING. MANUFACTURE AS PER DWG. SHIP QTY REQUIRED OF 89031009	Firmed	3/14/18	6 pcs	0 pcs <i>6x</i>	6 pcs	\$12.00/pcs	\$72.00
4	171045	RBST1007-5	Roller ISSUE P/O: _____ TO KG GRINDING. MANUFACTURE AS PER DWG. SHIP QTY REQUIRED OF 89031009 1 pin make 3 pcs	Firmed	3/14/18	6 pcs	0 pcs <i>6x</i>	6 pcs	\$12.00/pcs	\$72.00
5	RB KIT 407M-09	Gauge Pin 1-Issue P/O to KG Grinding; P/O _____ (Ship quantity req'd: 1 vial makes 4 pins) 2-Grind as per DWG. 3- Certificate of Conformity is required	Firmed	3/14/18	3 pcs	0 pcs <i>3x</i>	3 pcs	\$12.00/pcs	\$36.00	

*QAS
38
9-88*

AFFUTAGE K.G. INC. K.G. GRINDING INC.

40 ans
Depuis 1975

11455 Ave. Philippe Panneton
Montréal, Québec
Canada, H1E 4M1
Tél. : 514-323-0192
Fax : 514-323-6631

Distributeur d'outils de coupe & Affutage sur mesure
Distributor of cutting tools & Custom tooling

BON DE LIVRAISON DELIVERY SLIP

DATE: MAR-14-2018

DART AEROSPACE

73005

P.O. # 39202

QTÉ	LIVRÉE	B/O	DESCRIPTION	PRIX UNITAIRE	TOTAL
6	(6)	-	RBST4241-5		
26	(26)	-	RBST2854-5		
6	(6)	-	RBST1016-5		
6	(6)	-	RBST1007-5		
3	(36)	-	BB KIT 407M-09		
3	(36)	-	" - 07		
3	(36)	-	" - 15		
6	(67)	-	" - 23		
4	(4)	-	" - 21		
3	(36)	-	" - 05		
3	(36)	-	" - 11		
2	(2)	-	" - 17		
				SOUS-TOTAL	
				TPS	
				TVQ	
				TOTAL:	

REÇU EN BONNE CONDITION / RECEIVED IN GOOD ORDER

www.kggrinding.com • sales@kggrinding.com